

Date: Tuesday, 03/03/2009 4:17:11 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MAIN PANEL
Job Number : 46284	
Estimate Number : 13164	
P.O. Number :	Part Number : D37051
This Issue : 03/03/2009 S.O. No. :	Drawing Number : D3705 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 41225	Material :
Written By :	Due Date : 20/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 09.03.04</u>	
Comment : Est Rev:A 08-01-30 new issue EC verified by:DD Est Rev:B 09-01-09 rev.C prelim as per dwg DD verified by:EC Est Rev:C 09-02-20 rev.c as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 2.1651 sf(s)/Unit Total : 8.6604 sf(s) #
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 111003 IB 9-39

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3705
 Dwg Rev: C IB 9-39
 Prog Rev: C
 grain direction along 21.97
 2- Deburr if necessary IB 9-39



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



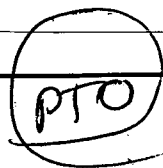
Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-COUNTER SINK AS PER DWG
 2- BEND AS PER DWG D3705

FF 09-03-18 (5)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 4:17:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN PANEL

Job Number: 46284

Part Number: D37051

Job Number:



Seq. #:

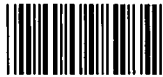
Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/03/23 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

50263

PC 9/2/23 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF
09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3705-1 PAR #: N/A Fault Category: Prod Line Ass'y ^{med & small} NCR: Yes No DQA: D Date: 09/03/20
D3705-03/041 D112-761-047
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/20

NCR: <u>46284</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/03/20</u>	<u>5</u>	<u>2 piece broke + 1 piece was out of tolerance</u> <u>x.c process/creating</u>	<u>[Signature]</u>	<u>destroy + scrap</u> <u>one of out tolerance</u> <u>keep for template</u> <u>N/A destroy</u>	<u>SB</u> <u>09/03/20</u>	<u>[Signature]</u> <u>09/03/20</u>	<u>[Signature]</u> <u>09/03/20</u>	<u>[Signature]</u> <u>09/03/20</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46284
Description: MAIN PANEL		Part Number: D3705-1
Inspection Dwg: D3705-1 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

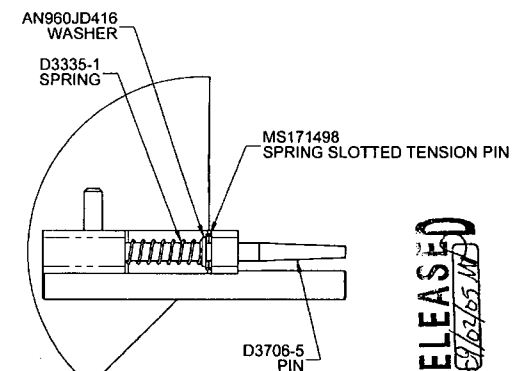
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.099	✓			
Ø .201	+ .005 - .001	.203	✓			
4.375	+/- .010	4.375	✓			
9.31	+/- .030	9.322	✓			
9.560	+/- .010	9.560	✓			
12.414	+/- .010	12.414	✓			
12.66	+/- .030	12.66	✓			
13.598	+/- .010	13.598	✓			
13.85	+/- .030	13.85	✓			
16.85	+/- .030	16.85	✓			
17.098	+/- .010	17.098	✓			
17.598	+/- .010	17.598	✓			
21.97	+/- .030	21.97	✓			
.375	+/- .010	.379	✓			
.573	+/- .010	.576	✓			
4.00	+/- .030	4.003	✓			
4.375	+/- .010	4.375	✓			
8.31	+/- .030	8.315	✓			
8.625	+/- .010	8.625	✓			
8.94	+/- .030	8.945	✓			
9.125	+/- .010	9.122	✓			
12.50	+/- .030	12.50	✓			
12.927	+/- .010	12.927	✓			

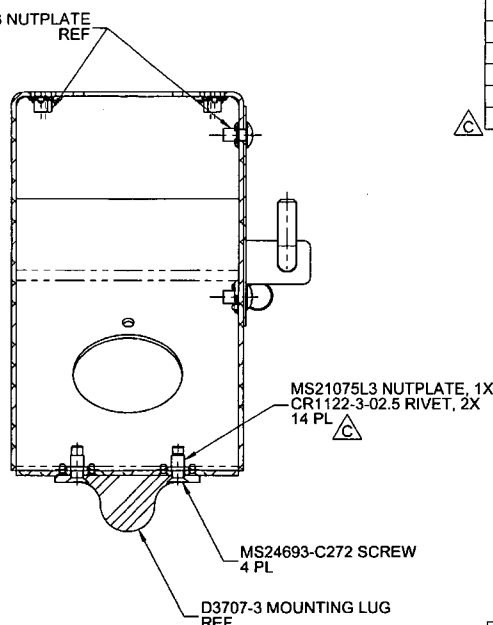
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 9-3-9	Date: 10-9-10	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

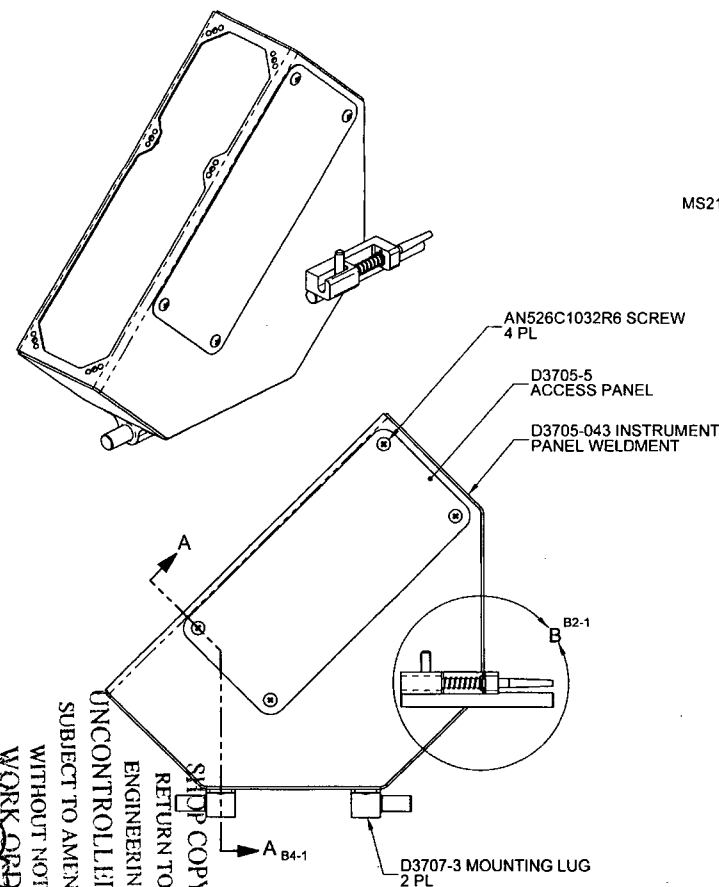
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



DETAIL B
SCALE 2X B6-1



SECTION A-A
SCALE 2X B7-1



D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 lbs

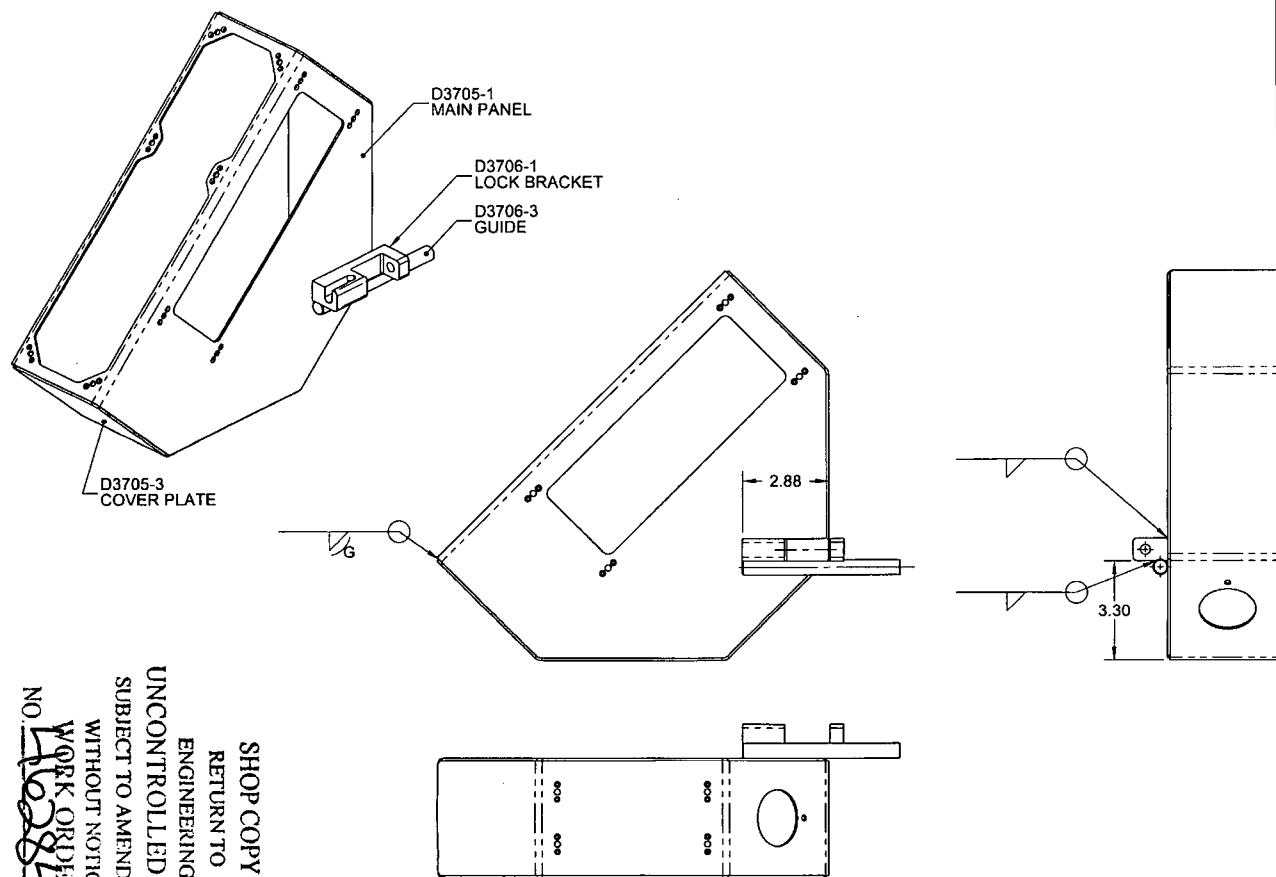
C	ADDED D3705-7/8-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.65 WERE 9.36 AND 12.61 (ZN B6-3); Ø 1.90 WAS 1.50 (ZN D5-4); ADDED Ø 0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS	MB	08.11.20
B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3); REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. C
SHEET 1 OF 6
TITLE **INSTRUMENT PANEL ASS'Y** SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

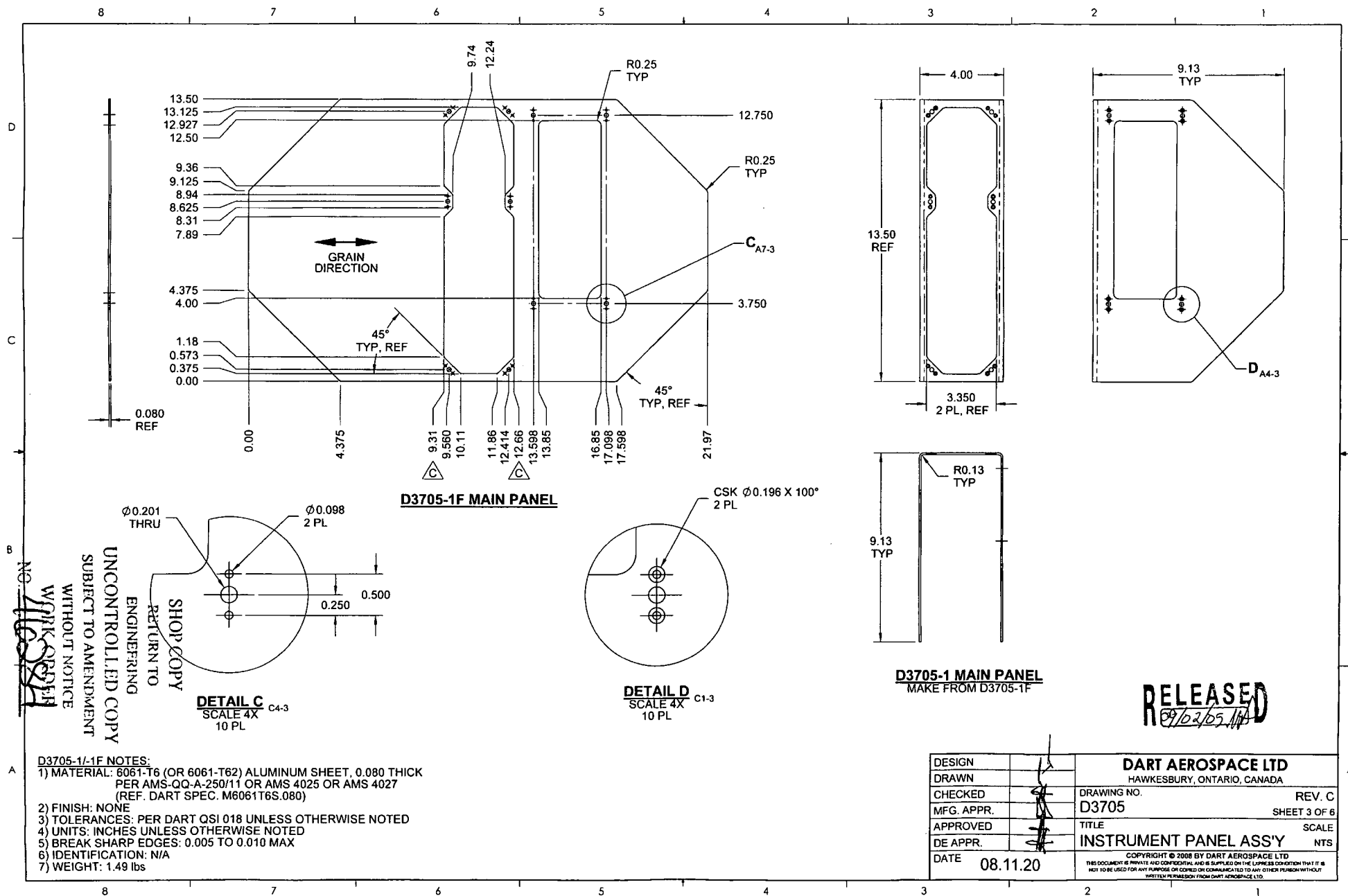
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 110284

D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
8/12/05 AM

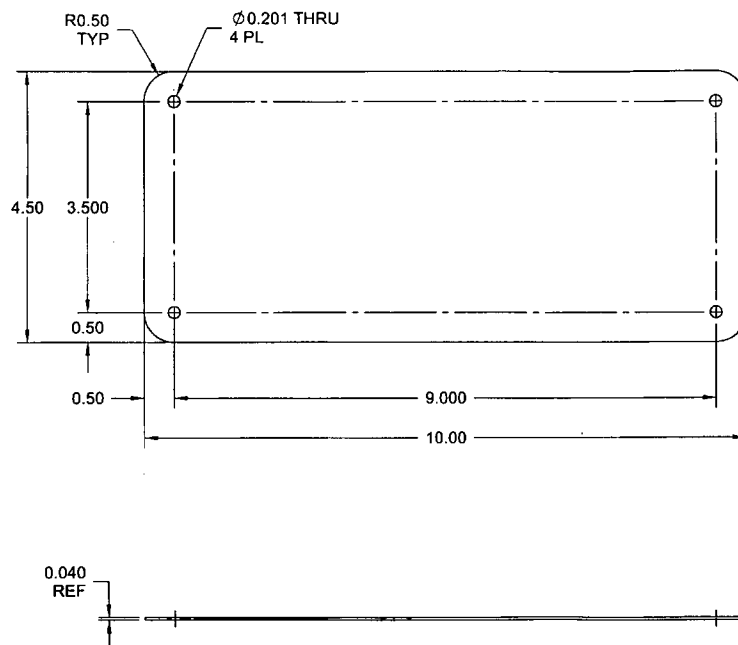
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3705	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		INSTRUMENT PANEL ASS'Y	SCALE
DE APPR.			NTS
DATE	08.11.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NO. 110324
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
UNCONTROLLED COPY
SHOP COPY
RETURN TO

- D3705-1F NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.49 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.11.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3705-5 ACCESS PANEL

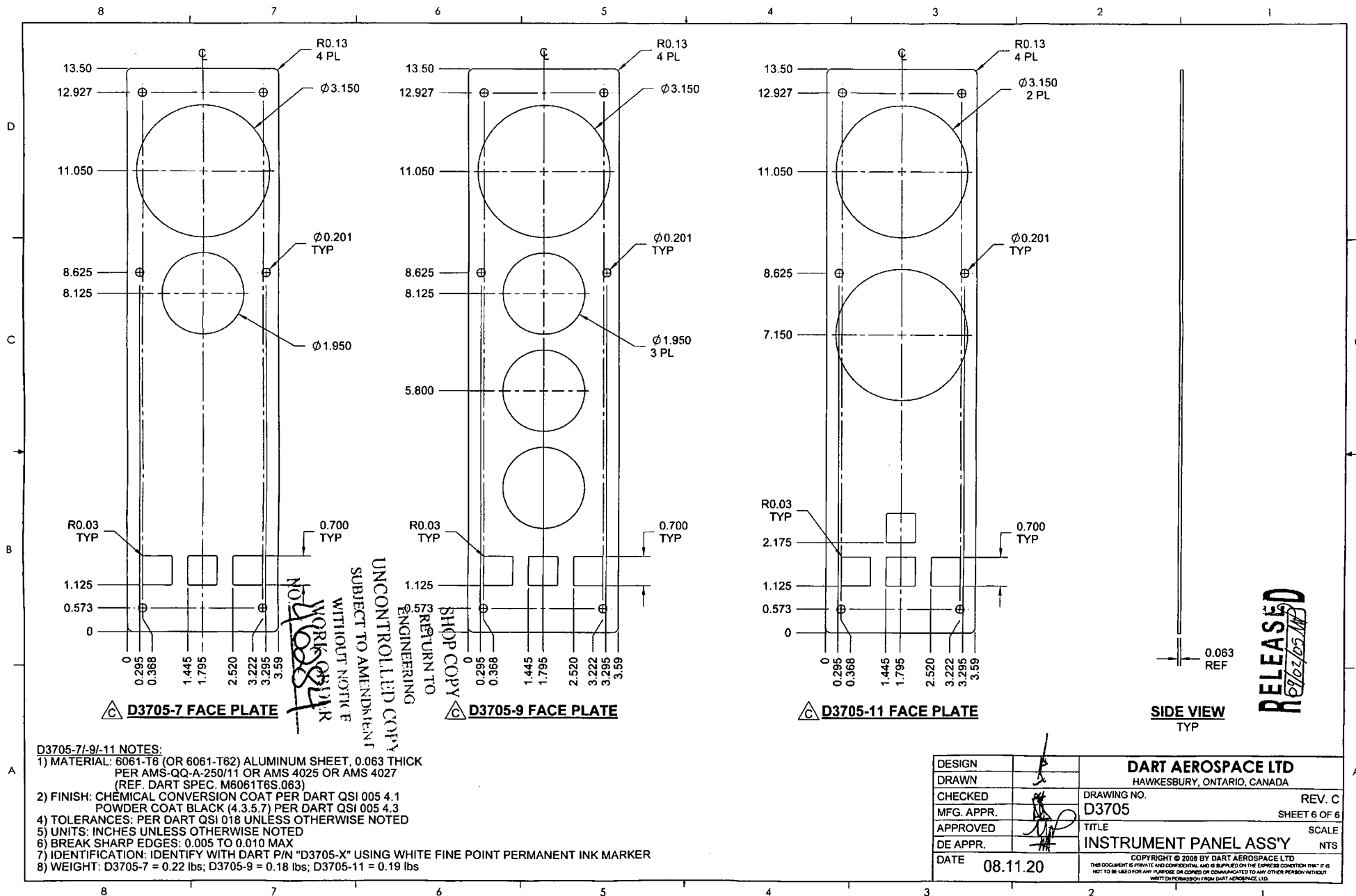
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 116387
WORK ORDER

RELEASED
09/12/05

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.11.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASSY	NTS
DATE	08.11.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	